



**ZJ 108 型**

# **自动磨刀剪裁机**

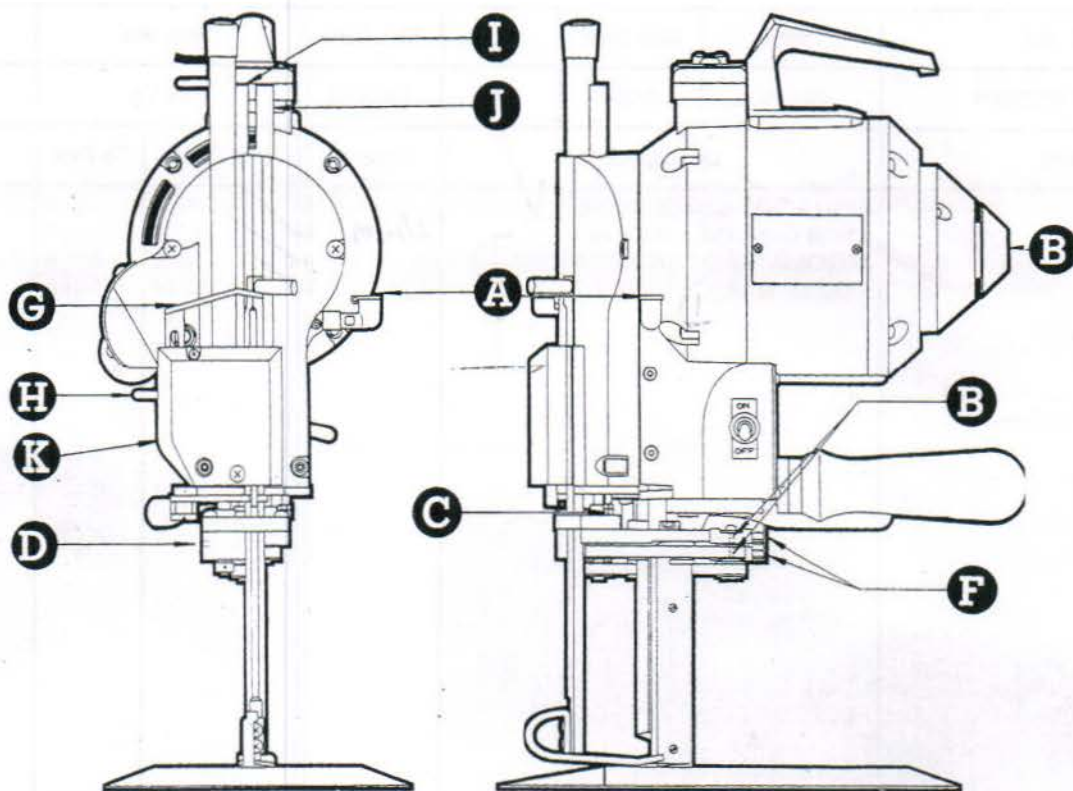
**AUTO-SHARPENING CUTTING MACHINE**

**使用说明书  
零件手册**

**OPERATION MANUAL  
PARTS BOOK**

**上海中捷缝纫机有限公司**  
**SHANGHAI ZOJE SEWING MACHINE CO., LTD.**

# OPERATION-LUBRICATION-CARE



### START ON

1. Fill oil cup A, be sure oil goes into smooth, if not, remove obstruction.
2. Push in E and turn the machine by hand for a few revolutions to make sure the oil is spread over contact surfaces.
3. The sharpener must be always up in locked position when starting.

### BE CAREFUL

- a. Keep the machine in warm place in cold weather.
- b. Repeat short on & off before permitting the machine to run continuously for preventing excessive friction between contact surfaces.
- c. Do not use too much oil. Do not use sewing machine oil. Use a least good grade of No. 30 motor oil.
- d. In case your cutter is of DUAL SPEED TYPE, please take care of the following two points:
  - (1) Be sure to select the switch to the upper high speed (HI) in starting, and then, when full revolution has been attained, to the lower speed (LO)  
The switch is put off by selecting the intermediate OFF
  - (2) The continuous operation at low speed (LO) should be no more than 30 minutes. DO NOT OPERATE FOR MORE THAN 30 MINUTES.

### LUBRICATION

EVERY 2 HOURS DAILY	ONCE A WEEK	ONCE A MONTH
1. Fill oil tank A (no need to oil at connecting rod bearing)	One drop oil to: 1. Tubes-1 & J 2. Turn Knob-E 3. Pulley Shaft-C 4. Belt Pulleys-B	Remove D plug and insert grease tube. Give a pea- size amount to the opening.

### SHAPENER OPERATION

1. Put the machine away from piles of material.
2. Drop pressure foot by lever located next to operating handle
3. Press lever G downward firm but not too quick.

### BE CAREFUL

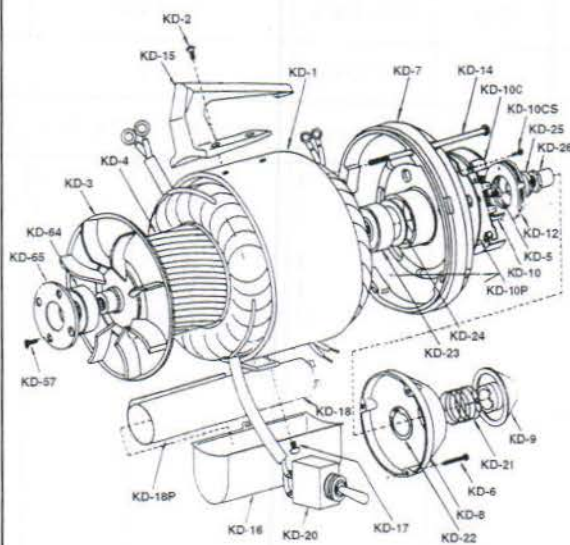
- a. Do not operate sharpener without knife in machine.
- b. Do not operate sharpener with cutting material laid in machine.
- c. Do not shut off motor while sharpener is in motion.
- d. If lever G is locked in halfway by too quick operation, lift lever H to unlock and start again.

### CARE

1. Blow lint out of motor and sharpener by blower or something alike twice a week.
2. Lint around screw mechanism of sharpener inside cover K must be cleaned once a week.
3. Clean the knife slide by slot cleaner once a day.
4. Remove lint from rollers in base plate. To prevent undue accumulation of lint, do not oil plate rollers. If rollers stick, remove from plate and wash in cleaning solvent.

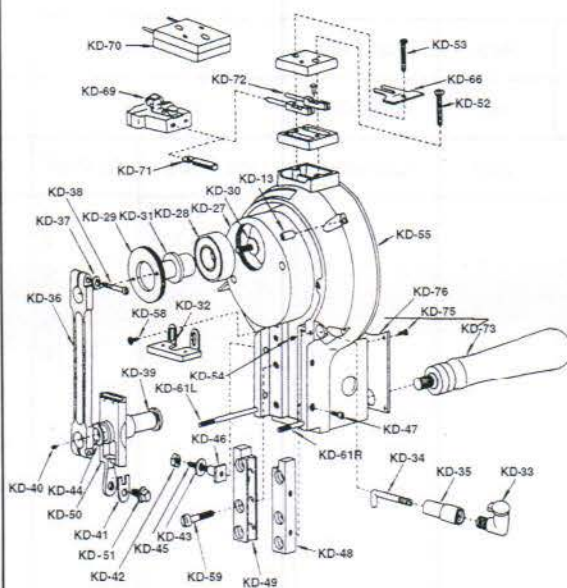


## MOTOR & HOUSING MECHANISM



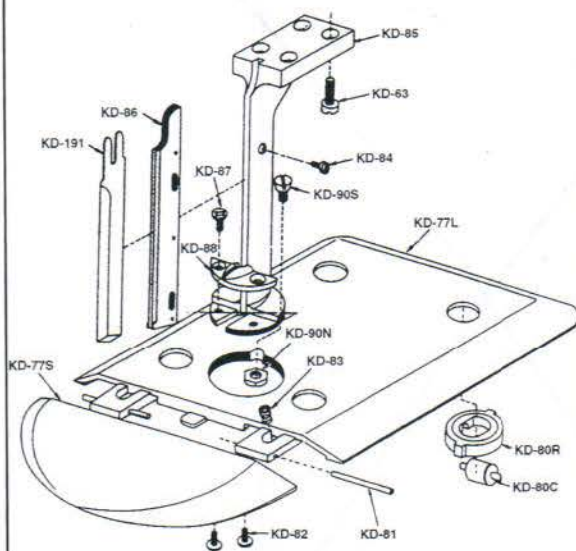
KD-1	Capacitor-Stator
KD-2	Carrying Handle Screws
KD-3	Rotor Fan
KD-4	Rotor with Shaft
KD-5	Cut-Out Switch to Bearing Screw
KD-6	Dust Cap Screw
KD-7	Rear Bearing Housing
KD-8	Dust Cap
KD-9	Turning Knob
KD-10	Cut-Out Switch
KD-10P	Insulated Plate
KD-10C	Insulated Cover
KD-10CS	Set Screw for Insulated Cover
KD-12	Automatic Cut-Out
KD-14	Front to Rear Bearing Screw
KD-15	Carrying Handle
KD-16	Capacitor Cover
KD-17	Screw for Capacitor Cover
KD-18	Capacitor
KD-18P	Paper
KD-20	Switch
KD-21	Clutch Spring
KD-22	Retaining Ring
KD-23	Rear Ball Bearing
KD-24	Rear Ball Bearing Spring Washer
KD-25	Clutch Nut
KD-26	Shaft Lock Nut
KD-57	Front Ball Bearing Retainer Screw
KD-64	Front Ball Bearing
KD-65	Front Ball Bearing Retainer

# FRONT COVER MECHANISM



KD-13	Front to Rear Bearing Nut
KD-27	Crank
KD-28	Crank Ball Bearing
KD-29	Crank Ball Bearing Lock Nut
KD-30	Screw for Brg Shaft
KD-31	Shaft for Ball Bearing
KD-32	Oil Pad Holder
KD-33	Oil Cup
KD-34	Oil Tube for Wrist Pin(Copper)
KD-35	Oil Tube for Wrist Pin
KD-36	Connecting Rod
KD-37	Shakeproof Washer
KD-38	Connecting Rod Clamp Screw
KD-39	Wrist Pin
KD-40	Wrist Pin Plug
KD-41	Knife Lock Washer
KD-42	Nuts for Guide Screw
KD-43	Guide Washer
KD-44	Connecting Rod washer
KD-45	Guide Adjusting Screw
KD-46	Guide Adjusting Nut
KD-47	Guide Lock Screw
KD-48	R.H.Guide
KD-49	L.H.Guide
KD-50	Cross Head
KD-51	Knife Lock Bolt
KD-52	Terminal Block Screw
KD-53	Ground Clip Screw
KD-54	Set Screw
KD-55	Front Bearing Housing
KD-58	Oil Pad Holder Screw
KD-59	Guide Hold Down Screw
KD-61L	Stud Lower L.H.Mountaing(L)
KD-61R	Stud Lower L.H.Mountaing(R)
KD-66	Ground Clip
KD-69	Attachment Plug(Complete)
KD-70	Tetminal Block(Complete)
KD-71	Terminal Sleeve
KD-72	Terminal Contact with Pin.
KD-73	Operating Handle
KD-75	Switch Cover Screw
KD-76	Switch Cover

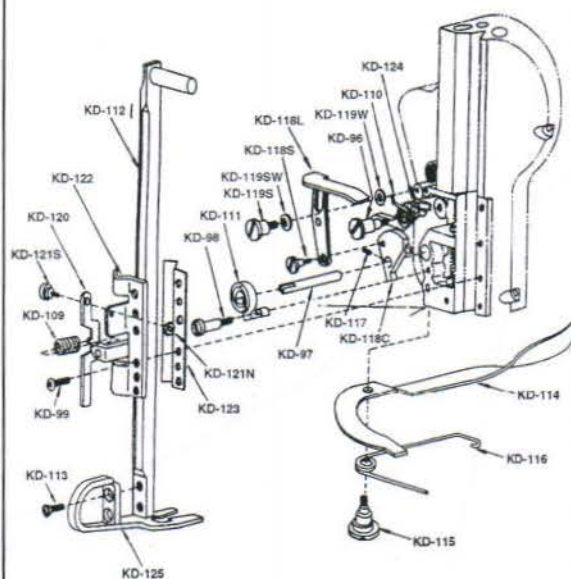
## STANDARD & BASE PLATES



<b>KD-63</b>	Standard-to-Bearing Screw
<b>KD-77S</b>	Plate Wing
<b>KD-77L</b>	Plate
<b>KD-80C</b>	Roller
<b>KD-80R</b>	Rubber
<b>KD-81</b>	Hinge Pin Short
<b>KD-82</b>	Hinge Pin Clamp Screw
<b>KD-83</b>	Plate Wing Tension Spring
<b>KD-84</b>	Knife Slide Screw
<b>KD-85</b>	Standard
<b>KD-86</b>	Knife Slide
<b>KD-87</b>	Screw for Throat Plate
<b>KD-88</b>	Throat Plate
<b>KD-90S</b>	Plate Screw
<b>KD-90N</b>	Plate Nut
<b>KD-191</b>	Knife



# SHARPENER HOUSING MECHANISM



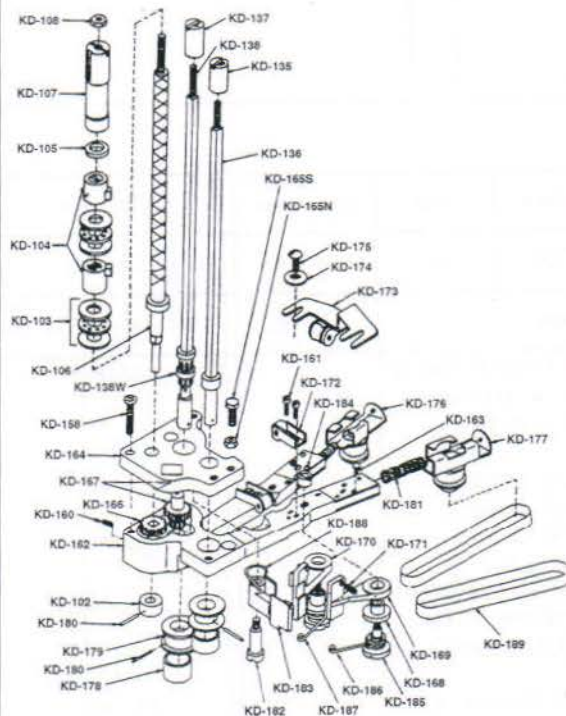
KD-96	Screw for Latch
KD-97	Shaft for Cam
KD-98	Cam Shaft Spring Screw
KD-99	Pres Foot Lock Bracket Screw
KD-109	Spring for Pressure Foot Lock
KD-110	Spring for Latch
KD-111	Cam Spring
KD-112	Pressure Foot Rod
KD-113	Screw for Pressure Foot Shoe
KD-114	Pressure Foot Lever
KD-115	Pressure Foot Lever Screw
KD-116	Spring for Pressure Foot Lever
KD-117	Set Screw for Cam
KD-118C	Cam
KD-118L	Release Lever
KD-118S	Screw for Cam
KD-119S	Lock Screw for Release Lever
KD-119SW	Spring Washer
KD-119W	Washer
KD-120	Lock(only)Pressure Foot
KD-121S	Screw for Pres Ft Lock
KD-121N	Nut for Pres Ft Lock
KD-122	Pressure Foot Lock Bracket
KD-123	Slide for Pressure Foot Rod
KD-124	Latch for Cam
KD-125	Pressure Foot Shoe

This exploded view diagram illustrates the assembly of the KD-100S electronic scale. The components are labeled as follows:

- KD-92**: Top cap screw
- KD-93**: Top cap screw
- KD-94**: Top cap screw
- KD-127**: Main vertical support post
- KD-134**: Side support bracket
- KD-133**: Side support bracket screw
- KD-152**: Side support bracket screw
- KD-100S**: Main scale body
- KD-60**: Scale body screw
- KD-100L**: Scale body screw
- KD-101**: Scale body screw
- KD-62**: Scale body screw
- KD-56**: Main vertical support post
- KD-144**: Main vertical support post
- KD-132**: Main vertical support post
- KD-145**: Main vertical support post
- KD-149**: Main vertical support post
- KD-155**: Main vertical support post
- KD-146**: Main vertical support post
- KD-150**: Main vertical support post
- KD-154**: Main vertical support post
- KD-156**: Main vertical support post
- KD-153**: Main vertical support post
- KD-151**: Main vertical support post
- KD-157**: Main vertical support post
- KD-126**: Main vertical support post
- KD-129**: Main vertical support post
- KD-140**: Main vertical support post
- KD-148**: Main vertical support post
- KD-129**: Main vertical support post
- KD-142**: Main vertical support post
- KD-143**: Main vertical support post
- KD-128**: Main vertical support post
- KD-130**: Main vertical support post
- KD-131**: Main vertical support post

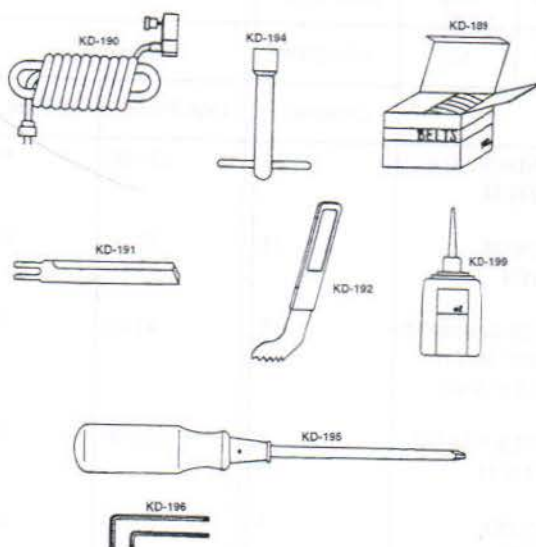


## LOWER GEAR BRACKET MECHANISM

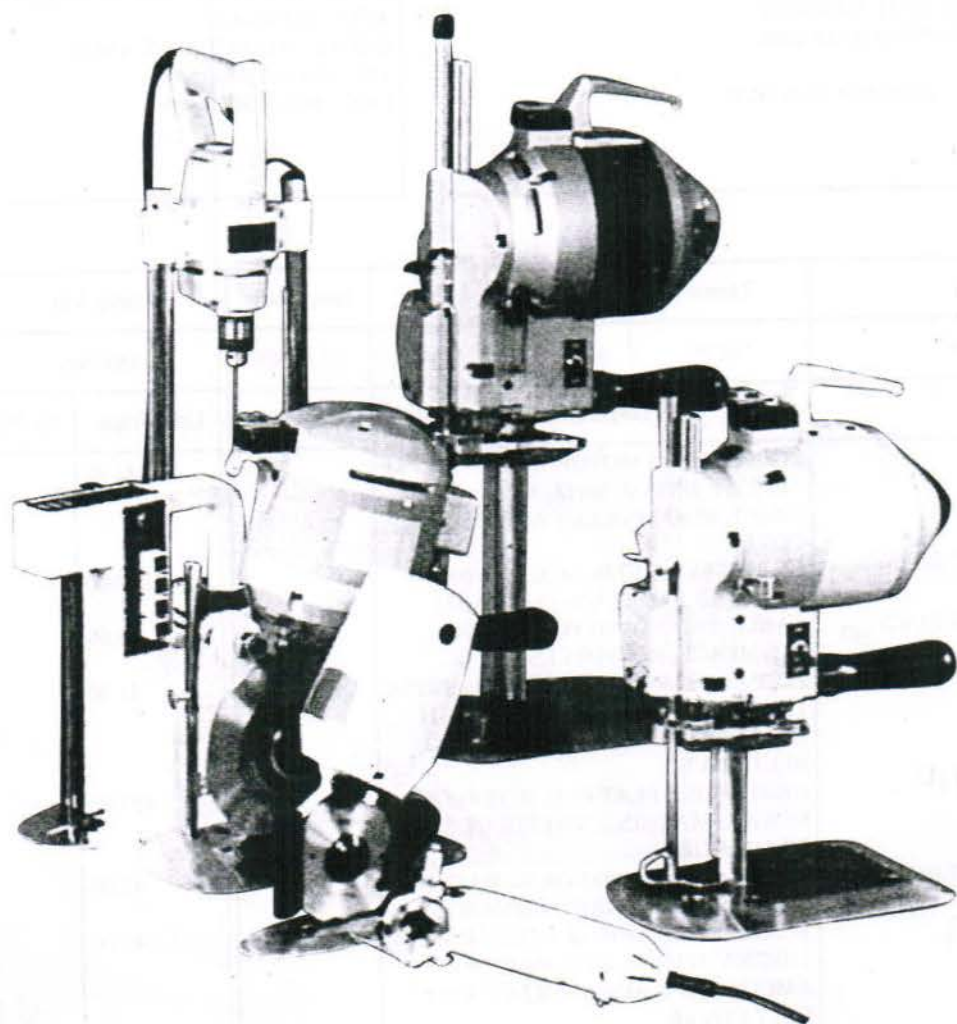


KD-102	Collar for Lower Screw Shaft
KD-103	Thrust Ball Bearing
KD-104	Nut for Screw Shaft L.H.& R.H
KD-105	Washer for Screw Shaft L.H.
KD-106	Screw Shaft With Extension
KD-107	Spacer Tube
KD-108	Stop Nut for Screw Shaft
KD-135	Right Hand Follower Nut
KD-136	R.H.Square Shaft
KD-137	Left Hand Follower Nut
KD-138	L.H.Square Shaft
KD-138W	L.H.Square Shaft Washer
KD-158	Screw for Gear Cover
KD-160	Grease Plug
KD-161	Screw for Stabilizer
KD-162	Lower Gear Bracket
KD-163	Screw for Slide Pulley
KD-164	Lower Gear Bracket Gear Cover
KD-165N	Adjusting Nut
KD-165S	Adjusting Screw
KD-166	Gear on Screw Shaft
KD-167	Intermediate Gear
KD-168	Bushing for Shoe
KD-169	R.H.Shoe
KD-170	L.H.Shoe
KD-171	Set Screw for Sharpener Shoe
KD-172	Stabilizer
KD-173	Guide Back of Standard
KD-174	Washer for Guide Back
KD-175	Screw for Guide Back
KD-176	L.H.Slide With Pulley
KD-177	R.H.Slide With Pulley
KD-178	Neoprene Band
KD-179	Front Pulley for Belts
KD-180	Roll Pin for Pulley
KD-181	Spring for Pulley Slide
KD-182	Screw for Clamping Arm
KD-183	Clamping Arm for Shoe
KD-184	Nut for Sharpener Shoe Screw
KD-185	Screw for Sharpener Shoe
KD-186	R.H.Sharpener Shoe Spring
KD-187	L.H.Sharpener Shoe Spring
KD-188	Spring for Arm
KD-189	Abrasive Belts

# ACCESSORY



<b>KD-189</b>	Abrasive Belts
<b>KD-190</b>	Electric Corde Complete
<b>KD-191</b>	Knife
<b>KD-192</b>	Slot Cleaner
<b>KD-194</b>	Knife Bolt Wrench
<b>KD-195</b>	Screw Driver
<b>KD-196</b>	Wrench for Shoe Set Screw
<b>KD-199</b>	Oiler







**ZOJE**

中捷

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